

Date: Monday, 10/11/2008 10:45:41 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: BASKET LID ASSEMBLY		
<b>Job Number</b>	: 43279A			<b>Part Number</b>	: D2989041		
<b>Estimate Number</b>	: 10206			<b>Drawing Number</b>	: D2989 REV C		
<b>P.O. Number</b>	:			<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 10/11/2008 <b>S.O. No.</b> :			<b>Drawing Revision</b>	: C		
<b>Prsht Rev.</b>	: NC			<b>Material</b>	:		
<b>First Issue</b>	: / / <b>Type</b> : LARGE FAB ASSY			<b>Due Date</b>	: 28/11/2008 <b>Qty:</b> 1 <b>Um:</b> Each		
<b>Previous Run</b>	: 42630A						
<b>Written By</b>	:						
<b>Checked &amp; Approved By</b>	: <u>JUL 08.11.10</u>						
<b>Comment</b>	: Est Rev:I Removed D2989-043 05-11-03 JLM Est Rev:J 08-08-29 revC as per dwg DD verified by:EC Est Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31663	Basket Hoop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick: Qty.(1) D3166-3 Batch: <u>1340624</u>	<u>DS 08/11/25</u>
2.0	D2581	Mounting Bracket	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick: Qty Part number      Description      Batch	
		✓ 2 D2581 Mounting Brackets <u>1340895</u>	<u>DS 08/11/25</u>
3.0	D23273	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick: Qty Part number      Description      Batch	
		✓ 2 D2327-3 Bushing <u>1339560</u>	<u>DS 08/11/25</u>
4.0	D2506	Label Plate	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick: Qty Part number      Description      Batch	
		✓ 1 D2506 Label Plate <u>1339457</u>	<u>DS 08/11/27</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

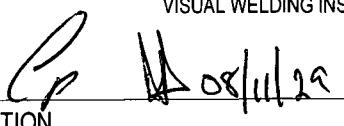
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BASKET LID ASSEMBLY
Job Number: 43279A		Part Number: D2989041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	M304EX07516F	Expanded Metal Flat SS 
Comment: Qty.: 15.0000 sf(s)/Unit Total : 15.0000 sf(s)		 <i>Sed 08/11/26</i>
Pick: <input checked="" type="checkbox"/> Qty Part number Description Batch 15sf M304EX0.75-16F Expanded Metal <i>m109383</i>		
6.0	M304TS0750W065	304 SQ Tube .75x.75x.065W 
Comment: Qty.: 31.7709 f(s)/Unit Total : 31.7709 f(s) 3/4" x 3/4" x 0.065" wall 304/316 SStubing. Batch: <i>m109846 m109731</i>		 <i>SAB 08-11-26</i> 
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1		
1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989		
2-Drill holes in tubing as D2989-041 per Dwg D2989		
3-Deburr and remove all markings on material		
4-Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required		
Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid		
5-Drill Ø0.257" hole as D2989-041 per Dwg D2989Identify as D2989-041  <i>SM 08/11/27</i>		
8.0	QC9	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION <i>CP 08/11/27</i>		
9.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP <i>S asstd 29</i>		
10.0	POWDER COATING	POWDER COATING  <i>M109152</i>  <i>(10)</i>
Comment: POWDER COATING		
1- Plug holes in D2581 prior to powder coating		
2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989 <i>M-1 08/11/28</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BASKET LID ASSEMBLY

Job Number: 43279A

Part Number: D2989041

Job Number:



Seq. #: Machine Or Operation:

Description :

3-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4

Spray Paint Black: M109195

Wing Walk: M109219

- FX 08/11/28 (X)

1ST COAT:

8 50

START TIME:

400 OF

OVEN TEMPERATURE:

400

FINISH TIME:

9 20

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

M-1 08/11/28

START TIME:

\_\_\_\_\_

OVEN TEMPERATURE:

\_\_\_\_\_

FINISH TIME:

\_\_\_\_\_

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



S 06/11/28 (X)

Comment: Inspect Powder Coat and Wing Walk

12.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/28 (X)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



M 08-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

C

B

B

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D2989-041	BASKET LID ASSEMBLY
X		D2989-043	BASKET LID ASSEMBLY
1		D2989-1	STRUT
1		D2989-2	STRUT
1		D2989-3	STRUT
1		D2989-4	STRUT
2		D2989-5	STRUT
2		D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2	2	D2989-17	STRUT
2		D2989-19	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
2		D3182-1	HINGE
2		D3442-3	SHIM

RELEASED  
08.06.21/14

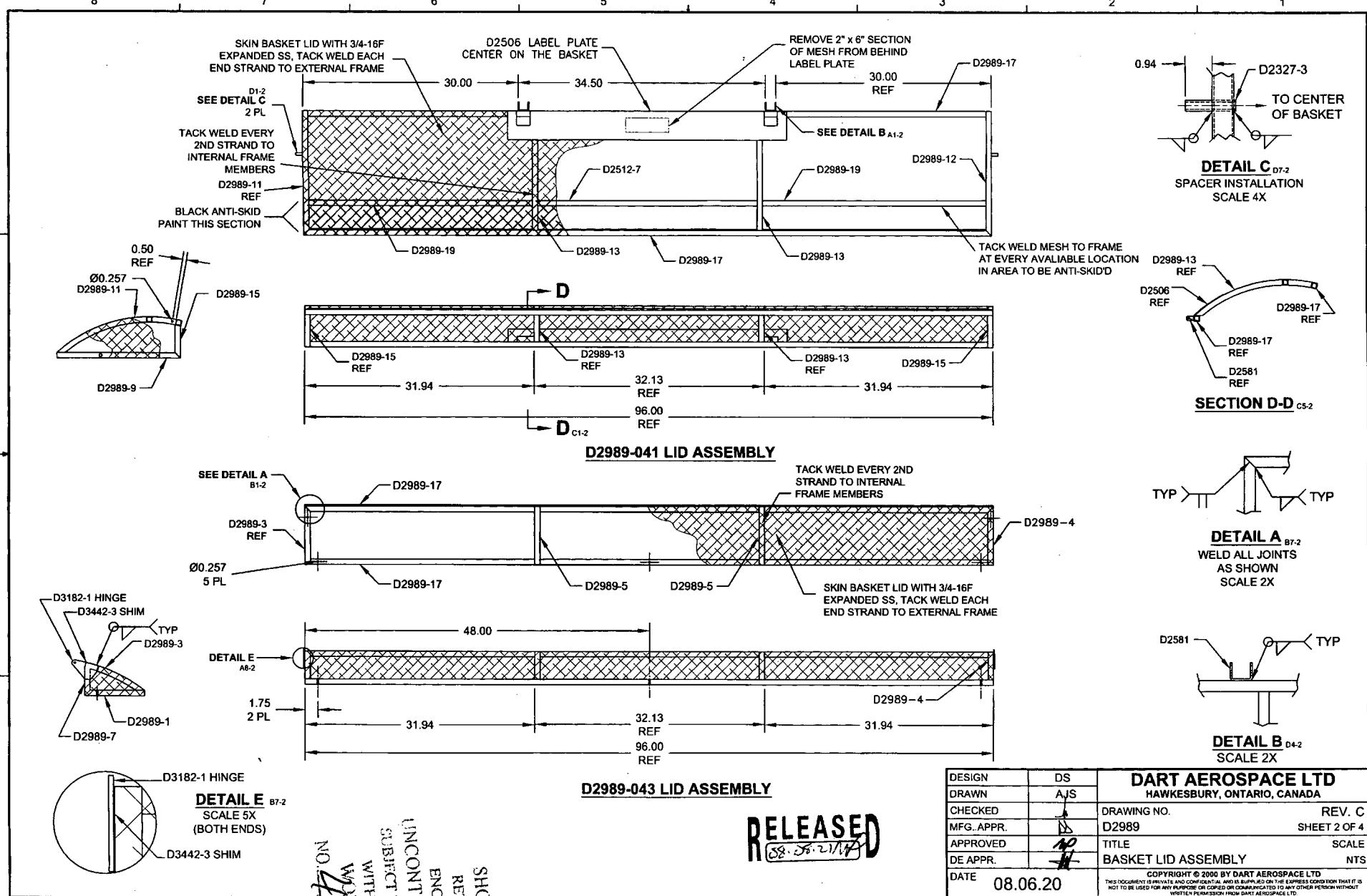
C

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065  
(D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

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NO. 432944  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHDRAWN NOTICE  
ENGINEERING

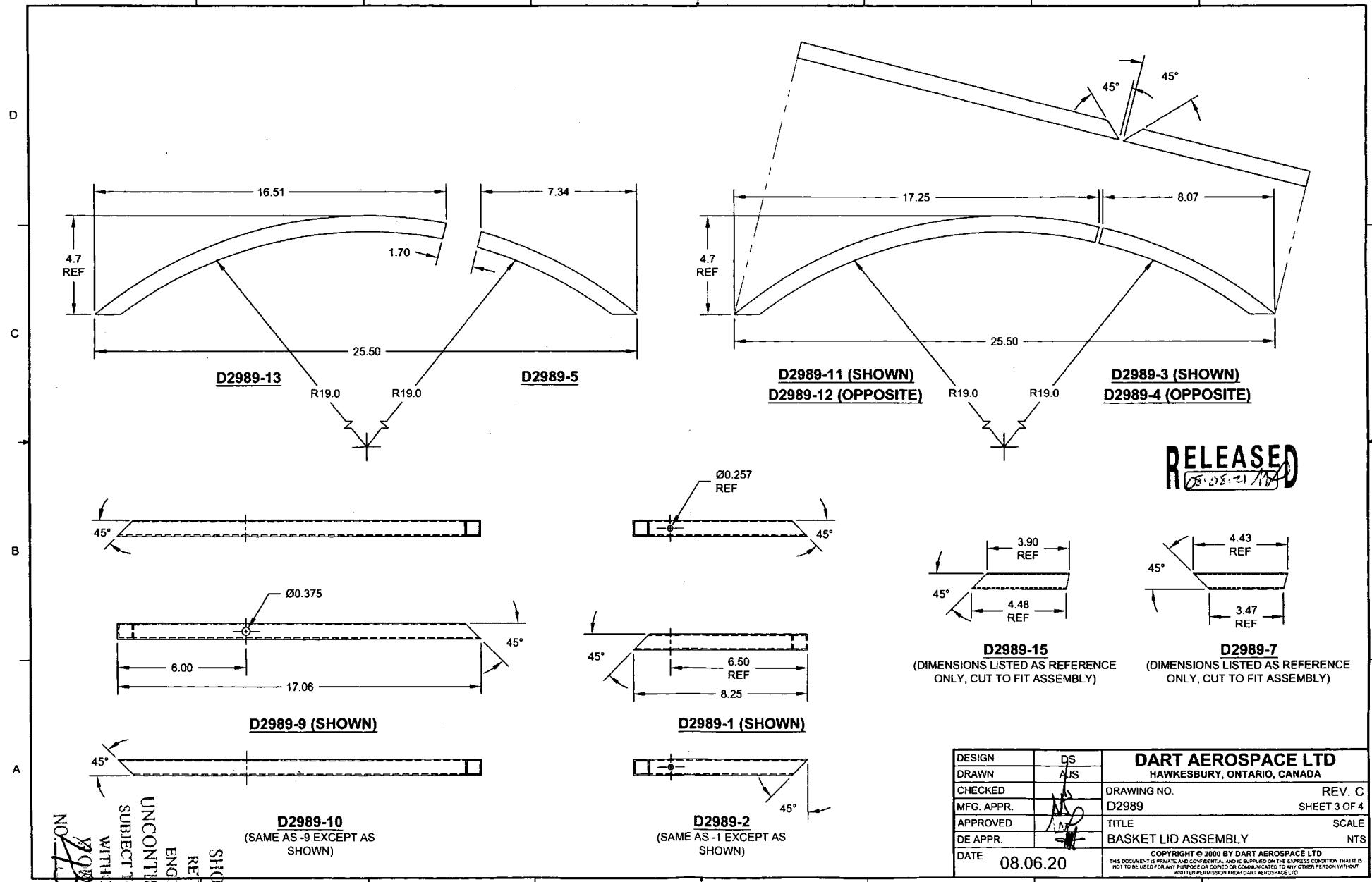
C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING TRANSFERRED TO "B" SIZE FORMAT & CURRENT DRAFTING STANDARD.			AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS			PH	05.06.07
A	NEW ISSUE			DS	00.10.27
REV.	DESCRIPTION			BY	DATE
DESIGN	DS	DART AEROSPACE LTD			
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO. REV. C			
MFG. APPR.		D2989 SHEET 1 OF 4			
APPROVED		TITLE SCALE			
DE APPR.		BASKET LID ASSEMBLY NTS			
DATE	08.06.20			COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



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MFG. APPR.	DA	DRAWING NO. REV. C
APPROVED	NP	D2989 SHEET 2 OF 4
DE APPR.	#	TITLE SCALE
DATE	08.06.20	BASKET LID ASSEMBLY NTS

8 7 6 5 4 3 2 1

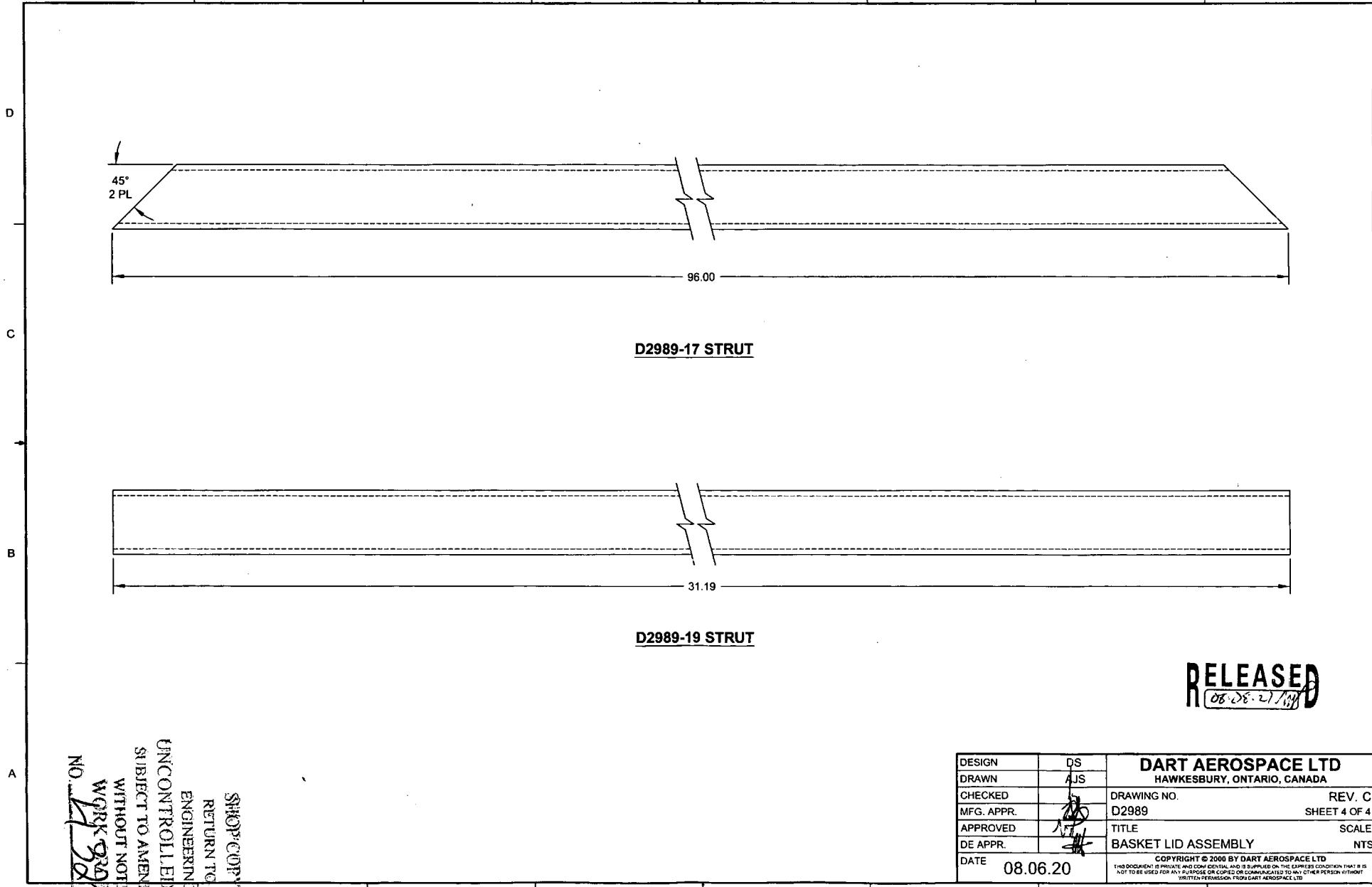


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APPROVED		REV. C	
DE APPR.		SHEET 3 OF 4	
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		BASKET LID ASSEMBLY	

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8 7 6 5 4 3 2 1



D2989-17 STRUT

D2989-19 STRUT

RELEASED  
08-06-27/19

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APPROVED		D2989
DE APPR.		SHEET 4 OF 4
DATE	08.06.20	TITLE
08.06.20		SCALE
		NTS
		BASKET LID ASSEMBLY

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